

ASAP 11

Work Order ID 58856

Wednesday, May 19, 2010 1:42:39 PM

Page 1

Item ID: D3942-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 5/19/2010 Start Qty: 50.00

Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 50.00

Customer:

Reference:

Approvals:

Process Plan: RP

Date: 10-5-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3942-1

Dwg Rev: A

Prog Rev: A

304.050

2-Deburr if necessary

10-5-20

(5)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-5-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 5/19/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S 10/15/26

count
(65)

QC

Memo

0.00

Quality Control

130

Memo

0.00

SA 10/15/20

(65)



Brake NC

0.00

Brake NC

1- Bend as per dwg D3942

140

QC5- Inspect part completeness to step on W/O

0.00

S 10/15/27

count
(65)

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 58856

Wednesday, May 19, 2010 1:42:39 PM



Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 5/19/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/10/12 7 (65)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01 7A

mk

10-5-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:42:43 PM

Page 1

Work Order ID: 58856

Parent Item: D3942-1

Parent Item Name: Angle

Comments:

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	140.0179	0.015	1.		



304/316 .050 Sheet



1310-5-26

Location

Loc Qty

Loc Code

MAT20

140.0179

108156

1.7

111743

10.1

112885

32.2179

113062

96

108156

(65)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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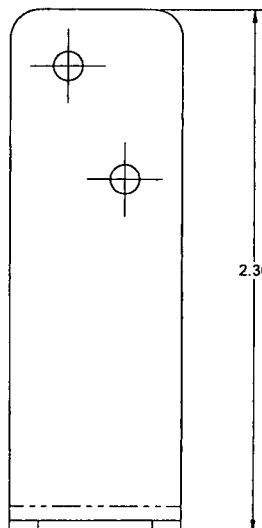
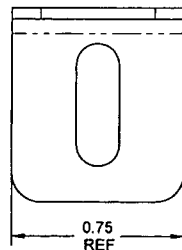
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58855

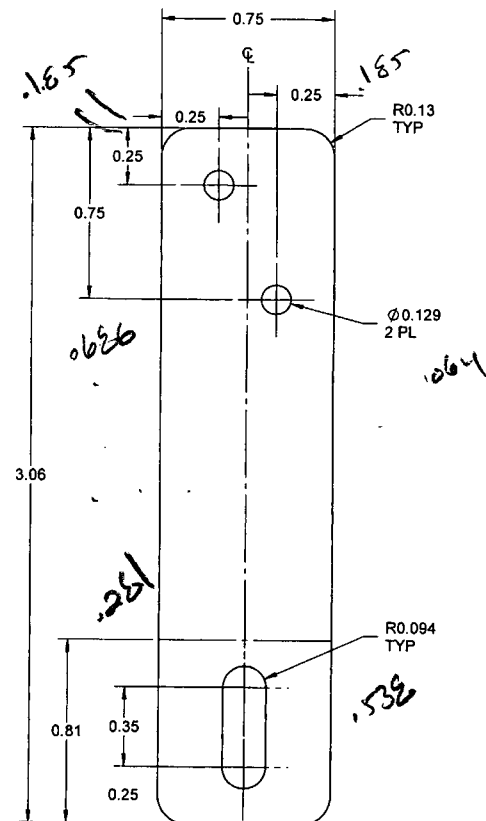
2/10-5-19



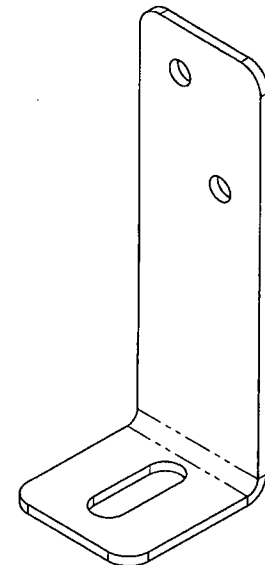
0.050
REF

R0.06

D3942-1 ANGLE
MADE FROM D3942-1F



D3942-1F FLAT PATTERN



RELEASED
09/06/12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A		NEW ISSUE		09.05.06		
REV.		DESCRIPTION		BY	DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	SHEET 1 OF 2	
DRAWN						
CHECKED		DRAWING NO.		SCALE	NTS	
MFG. APPR.		D3942				
APPROVED		TITLE		BRACKET		
DE APPR.						
DATE		09.05.06				

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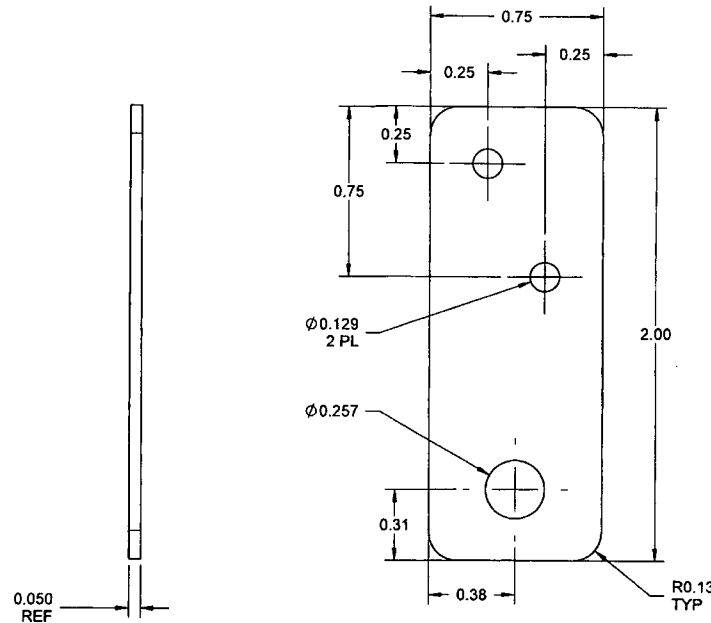
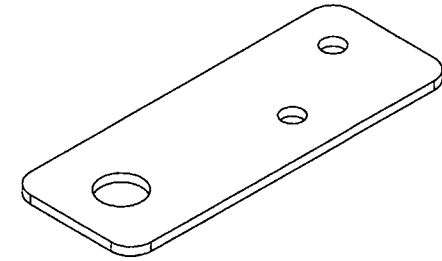
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3942-3 CLIP

w/o 5885C

RELEASED
09/06/06

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

DESIGN	95	DART AEROSPACE LTD	
DRAWN	95	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	EE	D3942	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	11	BRACKET	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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